

Date: Monday, 2/19/2007 8:08:03 AM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPAD |
| Job Number : 30758 | |
| Estimate Number : 12711 | |
| P.O. Number : <i>N/A</i> | Part Number : D35373 |
| This Issue : 2/19/2007 S.O. No. : <i>N/A</i> | Drawing Number : D3537 <i>UNDER REVIEW Rev 14 07.02.19</i> |
| Prsht Rev. : <i>NC</i> | Project Number : <i>N/A</i> |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : <i>U/R</i> |
| Previous Run : <i>N/A</i> | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 2/26/2007 Qty: 12 Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.02.19 | |
| Comment : Est Rev: A New Issue 07-02-14 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.1512 sf(s)/Unit Total : 1.8144 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: *M101031 M101873 M1 07 03 01*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: *A*Prog Rev: *A**SAD 07/03/01*

2-Deburr if necessary

(12)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/01

(12)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

07/03/02

(12)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3

Form Joggle as per Dwg D3537 on brake using Jig DT8158

SAB 07/03/05 12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/13/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:08:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 30758

Part Number: D35373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429 D3537 # 07.02.19

07/03/05 (12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

AR560 Hardcoat

M02755

Weld hardcoat as per Dwg D3429 D3537

FC 07/03/12 (12)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/13/12 (12)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/12 (12)

10.0

POWDER COATING

POWDER COATING



M101601



(12x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/03/15

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/13/15 (12) LC

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/13/15 (12)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



4 07/03/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

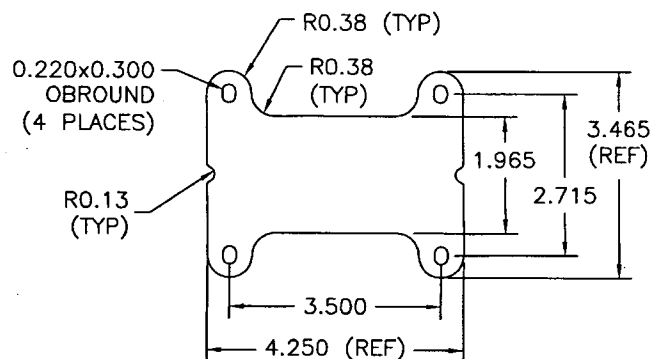
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

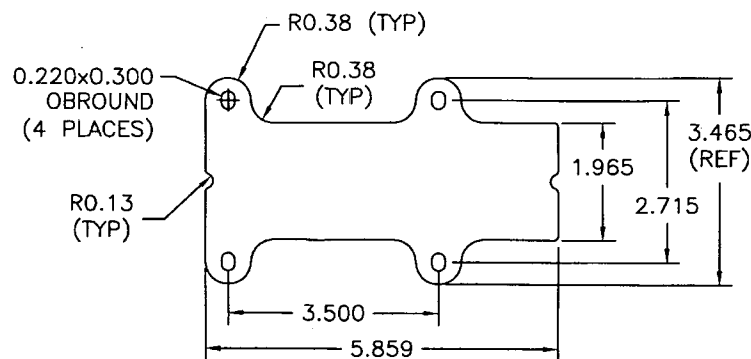
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

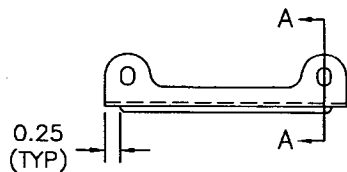
D3537-1F FLAT PATTERN



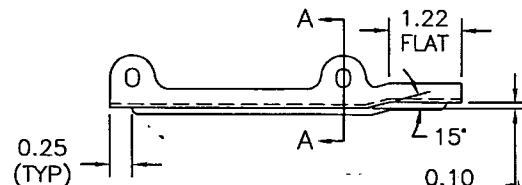
D3537-3F FLAT PATTERN



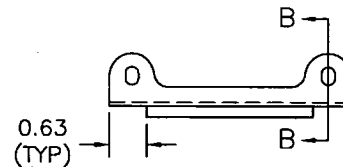
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



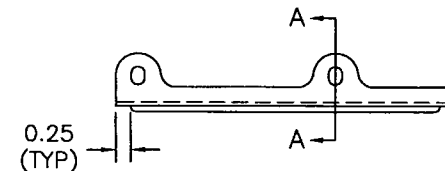
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



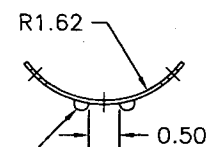
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

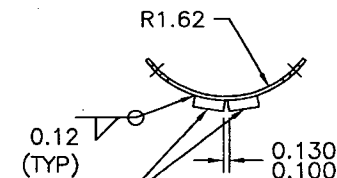


SECTION A-A



2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED

07.02.12

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
NO. 30758
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

| | | |
|---------|----------|-------------------------------|
| A | 06.11.06 | NEW ISSUE |
| DESIGN | CB | DRAWN BY |
| CHECKED | PH | APPROVED |
| DATE | 06.11.06 | TITLE |
| | | WEARPAD |
| | | DART DART AEROSPACE USA, INC. |
| | | PORT HADLOCK, WA |
| | | DRAWING NO. |
| | | D3537 |
| | | REV. A |
| | | SHEET 1 OF 1 |
| | | SCALE |
| | | 1:2 |

